

Work Order ID 111127

January-09-14 11:56:16 AM

111127

Rev E 514/1.1/24
~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4634-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Fwd, Center Ceiling Panel Assembly
Start Date: 09/01/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: AP/MLJ Date: 14-01-09 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4634	PER E <u>PER E</u>

100 0.00

100

HandThermo

Memo

Hand Finishing Thermoforming

Pick Kit

0.00

① S/D 14/01/23

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D4634-041 ✓

2- install No Smoking & seat belt symbols ✓

3- Install led lights ✓

4- Install Air valves ✓

5-Install Wiring Harness ✓

~~5-Install wiring harness~~

② 14/01/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 111127

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111127

Page 2

Item ID: D4634-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Panel Assembly
Start Date: 09/01/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 24/01/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 DAS 27 9-89 14/1/23				1 Inspect as per Rev PE			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00 Thermofarming				MLJ			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ 14-01-23			

POSITIVE RECALL
EFFECTIVE 14/01/22 AUTH h
RELEASED S DATE 14/01/24

POSITIVE RECALL
EFFECTIVE 14/01/24 AUTH h
RELEASED _____ DATE _____

Release DWG as per
Rev E

MLJ 14-01-23
DAS
27
9-89
14/1/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Training									
Transport									
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Tuesday, January 21, 2014 1:19:12 PM

3

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
release DL VERIFIED BY:JLM IPP Rev B 12/11/08 Document
IPP Rev C 13/07/09 Dwg Update DL verf: DD
IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg update 14/01/20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4743-1		Manufactured	No				Each	30.0000		2			
Speaker Grill													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST122		30							
				(111220)		30							
MS21044-N08		Purchased	No				Each	265.0000		8			
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST315		265							
				(123741)		115							
				m127813		150							
MS24693-BB50		Purchased	No				Each	100.0000		8			
SCREW													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		100							
				(m127924)		100							
NAS1149DN832J		Purchased	No				Each	3,348.0000		8			
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST293		1000							
				M127813		1000							
				st510		376							
				124555		376							
				ST510a		1972							
				(M126319)		972							
				M127255		1000							
D4634-141		Manufactured	No			100	Each	0.0000	1	1			
Fwd, Center Ceiling Replacement Panel Assembly													
							B111148		SAD			14/01/22	

Picklist Print

Tuesday, January 21, 2014 1:19:12 PM

Page 2

Work Order ID: 111127

Parent Item: D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

D4646-1
Plenum Cap Assembly

Manufactured No

100 Each 84.0000

2

SAD 2 14/01/22

Location

Loc Qty

Loc Code

ST116

84

103832

66

92968

6

95779

12

D4652-1
Air Valve, 1.16 Id Disk Type

Manufactured No

100 Each 203.0000

2

2 mm.L 14/01/22
SAD 2 14/01/22

Location

Loc Qty

Loc Code

prelim

12

111316

12

ST099

191

111311

191

D4728-047
Advisory Light, Fwd

Manufactured No

100 Each 0.0000

1

2 B111317 2 mm.L 14/01/22
SAD 1 14/01/22

D4728-051
Cabin Lights #1

Manufactured No

100 Each 1.0000

1

1 B111173 1 mm.L 14/01/22
SAD 1 14/01/22

Location

Loc Qty

Loc Code

ST121

1

93456

1

1 mm.L 14/01/22

PLT1.5M-M
Tie Wrap

Purchased No

100 Each 1,008.0000

8

8

Location

Loc Qty

Loc Code

ST389

1008

124363

8

m126551

1000

8 mm.L 14/01/22

50-009-2
Grommet

Purchased No

100 Each 1.0000

1

1 mm.L 14/01/22
SAD 1 14/01/22

Location

Loc Qty

Loc Code

ST378

1

122594

1

m128022 1

Tuesday, January 21, 2014 1:19:13 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, January 21, 2014 1:19:13 PM

Page 3

Work Order ID: 111127

Parent Item: D4634-041

Parent Item Name: Fwd, Center Ceiling Panel Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

2351-20-27-C3C

Purchased

No

100

Each

80.0000

1

1

STUD

Location

Loc Qty

Loc Code

ST396

80

m126740

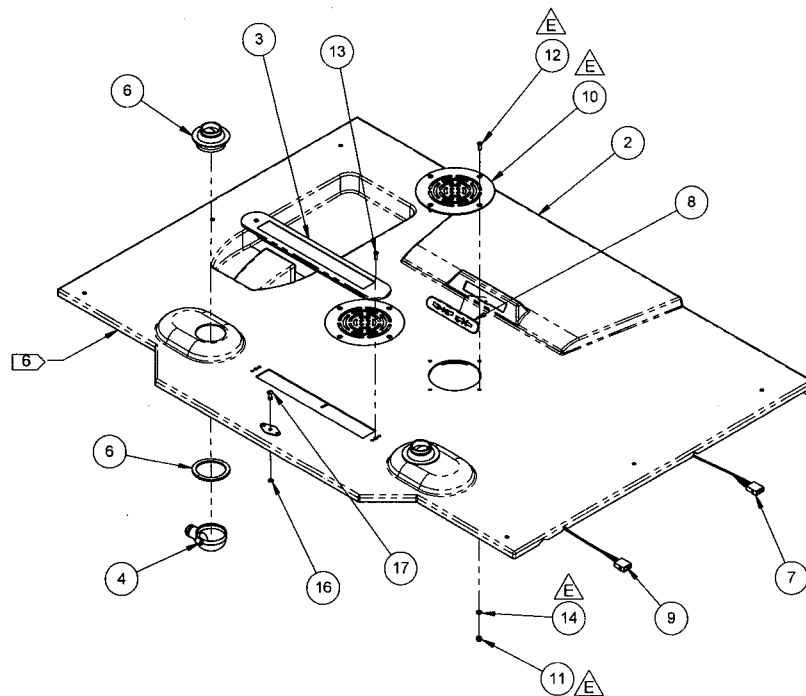
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m127922

50

1

mm. 14/01/22



D4634-041 FWD, CENTER CEILING PANEL ASSY

NOTES:

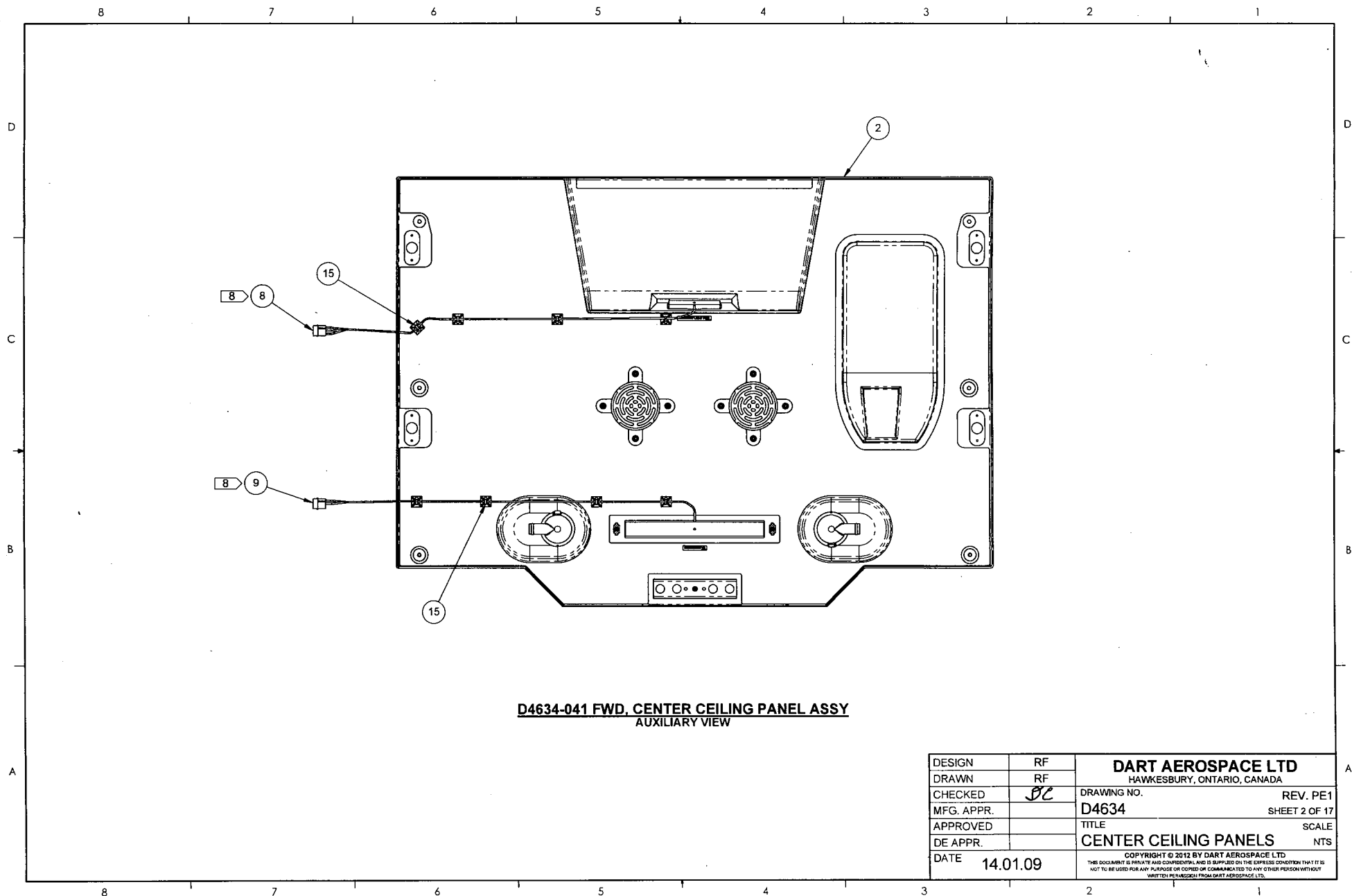
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.24 lbs
- 8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

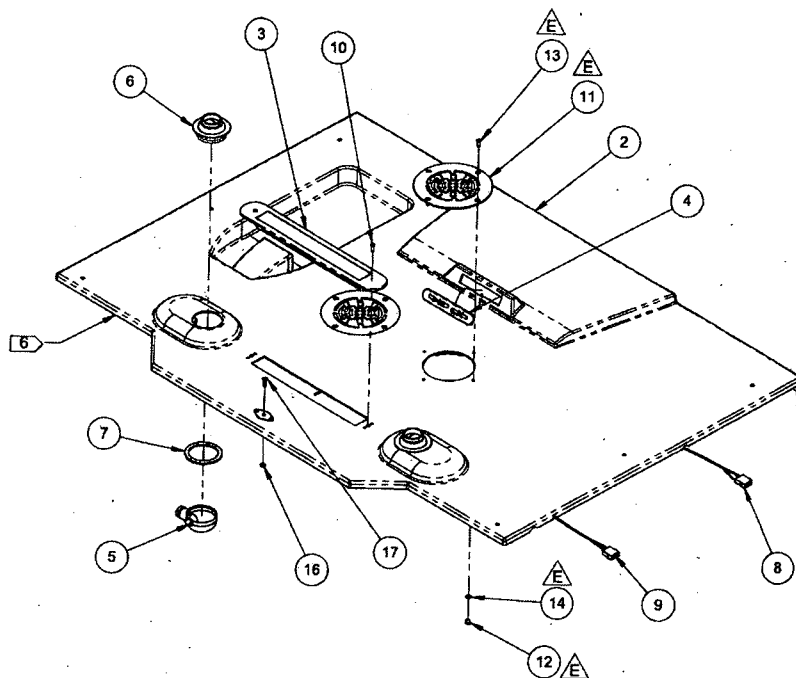
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1 ✓	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2 ✓	D4646-1	PLENUM CAP ASSEMBLY
5	2 ✓	D4652-1	AIR VALVE
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1 ✓	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
8	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
9	1 ✓	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	D4743-1 ✓	SPEAKER GRILL
11	8 ✓	MS21044-N08	NUT
12	8	MS24693-BB50 ✓	SCREW
13	2 ✓	N/A (REF)	SCREW (PART OF D4728-051)
14	8	NAS1149DN832J	WASHER
15	8 ✓	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2 ✓	GROMMET
17	1 ✓	2351-20-27-C3C	STUD

PRELIMINARY ISSUE

14.01.09

E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C6-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-16)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C6-6); D5021-1 (ZN D4-7, D5-7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPHY-750S-9-C (ZN D4-9, B7-9); Ø0.129 (ZN B4-11, B4-13); DETAIL "UP" (ZN C2-17); 3.83 WAS 3.87 (ZN C6-11); 2.00 WAS 2.02 (ZN D6-13); REVISE NOTE 8) & 10) (ZN A8-7, A8-8, A9-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/-3/-5; Ø0.250 WAS Ø0.206 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-8); Ø0.206 WAS Ø0.207 (ZN D6-11, C3-13, C6-15) ADD DIM. (ZN B6-7, B7-7, D7-8, & D6-8)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R.S.T SHT 10, 12, 14, 15, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 1 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





D4634-041 FWD, CENTER CEILING PANEL ASSY

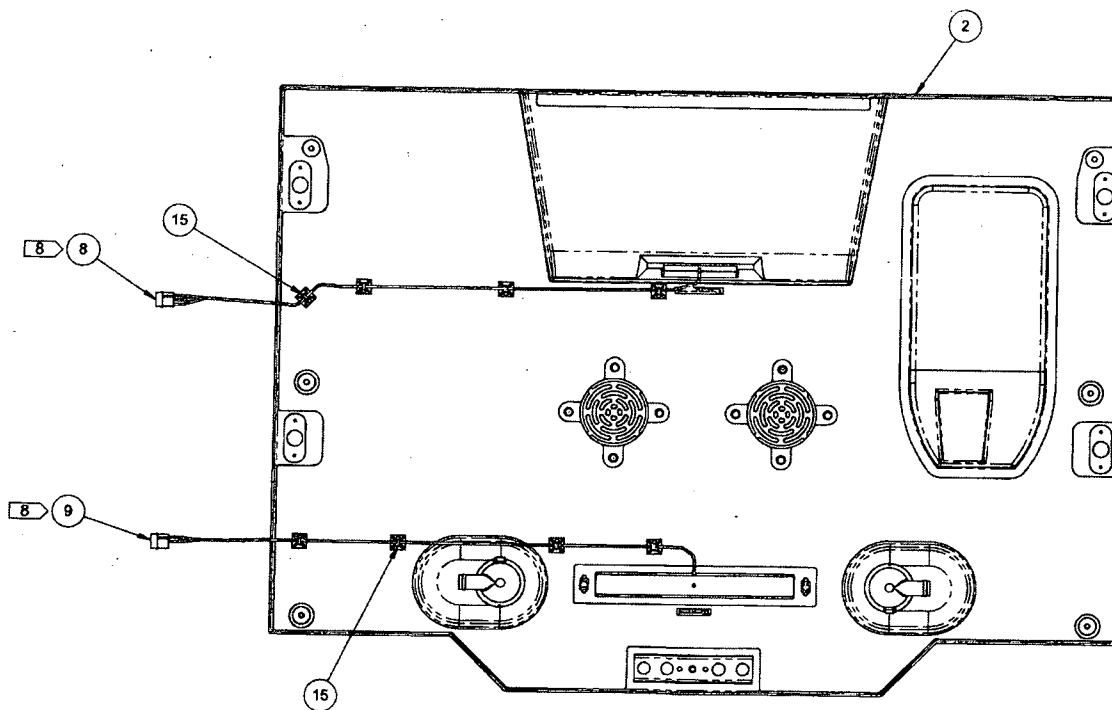
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.0 lbs
- 8) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	1	D4645-1 (REF)	NO SMOKING & FASTEN BELT LIGHT (PART OF D4728-047)
5	2	D4848-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
8	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
9	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
10	2	N/A (REF)	SCREW (PART OF D4728-051)
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT
13	8	MS24693-BB50	SCREW
14	8	NAS1149DN832J	WASHER
15	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
16	1	50-009-2	GROMMET
17	1	2351-20-27-C3C	STUD

E	REVISED BOM (ZN C4-1, C4-3, D4-5, C4-7, C4-8, C4-9); ADDED NOTE 11) (ZN D5-7, A8-7, D5-8, A8-8, D7-9, A8-9); 3.70 WAS 3.83 (ZN C6-11); 1.88 WAS 2.00 (ZN D7-13); 6.13 WAS 6.25 (ZN B6-15); REVISE DETAIL B (ZN A8-18)	RF	14.01.09
D	ADDED PLT1.5M-M (ZN C4-5, C6-6); D5021-1 (ZN D4-7, D5- 7); D5021-3 (ZN D4-8, D5-8); D5021-5 (ZN D4-9, B7-9); MPNY-750S-9-C (ZN D4-9, B7-9); Ø 0.120 (ZN B4-11, B4- 13); DETAIL "U" (ZN C2-17); 3.83 WAS 3.87 (ZN C6-11), 2.00 WAS 2.02 (ZN D6-15); REVISE NOTE 9) & 10) (ZN A8-7, A8- 8, A8-9); & NOTE 1) (ZN A8-10, A8-12, A8-14); 3.80 WAS 3.84 (ZN D4-17, B8-17); REMOVED D4694-7/-041/-043/-045/-047, D4647-3/-7/-8; DIMENSION SHIFTED DUE ADDING D5021-1/- 3/-5; Ø 0.250 WAS Ø 0.208 (ZN D6-11, C3-13 & D6-15)	RF	13.12.09
C	REVISE GENERAL NOTES (ZN A8-7, A8-8, A8-9) & BOM (ZN D4-1, D4-3, D4-5, D4-7, D4-8); Ø 0.208 WAS Ø 0.207 (ZN D6- 11, C3-13, C6-15) ADD DIM. (ZN B8-7, B7-7, D7-8, & D6-8)	RF	13.06.18
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. E
MFG. APPR.	BC	D4634	SHEET 1 OF 17
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CENTER CEILING PANELS	NTS
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D4634-041 FWD. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

2014-01-22
JH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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